

Work Order ID 142271-1

Thursday, March 10, 2016 8:01:54 AM

142271-1

Page 3

Item ID: D2938-2**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Saddle RH Out, 206**Start Date:** 3/10/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 3/17/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run Start *NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

Quality Control

*Cancelled**W 16-03-14*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle RH Out, 206

Start Date: 3/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/17/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.02

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

QC1- Inspection performed by CMM

0.00

120

QC

Memo

0.00

Quality Control

Picklist Print

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Work Order ID: 142271-1

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Parent Item: D2938-2

D2938-2

Parent Item Name: Saddle RH Out, 206

Start Date: 3/10/2016

Required Date: 3/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	41.0000	1	1			

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT046

41

138991

11

140552

10

141201

20

DART AEROSPACE LTD		Work Order: 142271
Description: 206 Saddle, Outboard, Right side		Part Number: D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140							
B	0.100	0.140							
C	0.100	0.140							
D	0.210	0.230							
E	1.245	1.255							
F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
J	2.495	2.505							
K	0.257	0.262							
L	0.312	0.317							
M	0.235	0.240							
N	0.100	0.140							
O	0.540	0.560							
P	0.490	0.510							
Q	3.715	3.725							
R	2.720	2.760							
S	0.240	0.270							
T	0.100	0.180							
U	1.625	1.635							
V	1.362	1.372							
W	0.316	0.321							
X	1.250	1.270							
Y	1.565	1.585							
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

142271

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Accept/Reject									

Measured by:	
Date:	

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Date:	

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A		New Issue	RF	
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DQA: _____ Date: _____

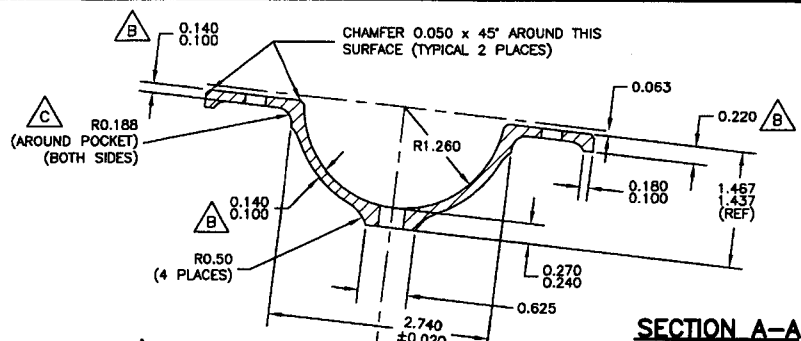


WORK ORDER NON-CONFORMANCE / UPDATE

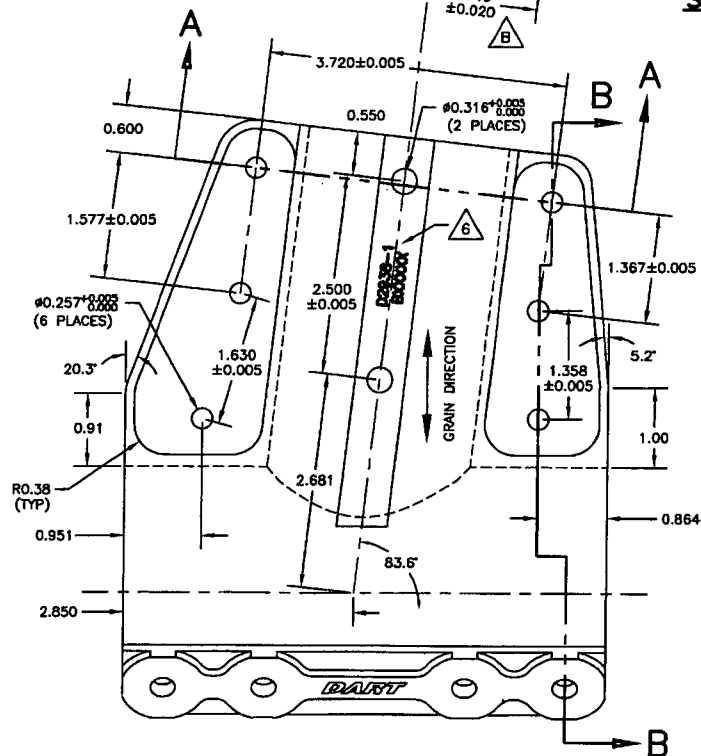
QA Closed: _____ Date: _____

Work Order update only ☐

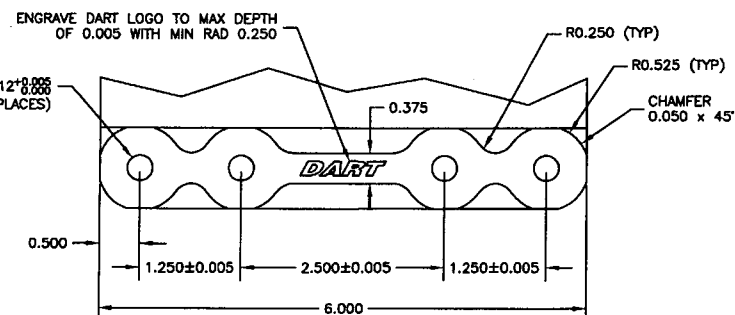
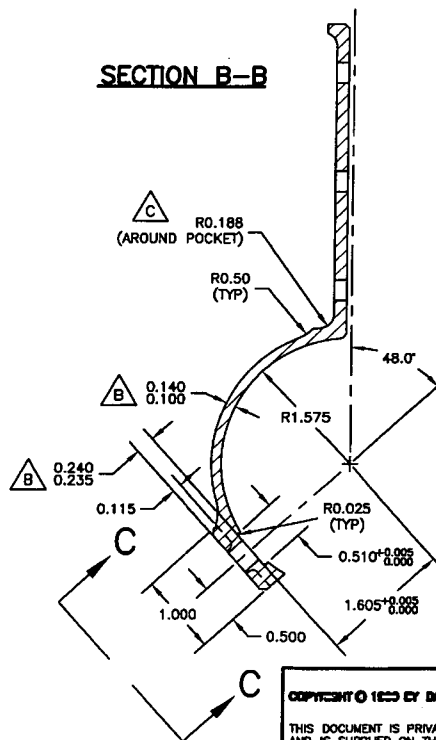
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____						



SECTION A-A



SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

20160304
142271
SHE 136223 20160901

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
DRAWING NO.	D2938	REV. C
SHEET 1 OF 1		SCALE
		2:3

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